

Work Order ID 74474 -1

Monday, October 03, 2011 9:44:13 AM

Page 1

Item ID: D2661-2
Revision ID:
Item Name: Saddle, RH Fwd Aft Out 206

Accept

Setup Start

Stop

Start Date: 9/30/2011 Start Qty: 10.00
Required Date: 10/28/2011 Req'd Qty: 10.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: H.L.J. Date: 11/10/03 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2661	Rev D

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Program part number and batch number. ☐ Fixturing Inspection last completed by BA 11/11/11
☐ 1-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually inspect as per attached Dimension

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

0.00

Memo

Machine Keyway and inspect per attached dimension sheet

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

Split-1

SCRAP

BA 11/11/11
FK 11/11/13

BA 11/11/14

BA 11/11/11
FK 11/11/13

10 d PO →

W/O: 74474-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2661-2

PAR #: N/A

Fault Category: Machinery

NCR: Yes No

DQA

Date: 11/11/24

Resolution: Scrap

Disposition: Scrap

QA: N/C Closed: CK

Date: 11/11/30

NCR: 11-1017

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/24	110	Qty +3 saddles have the code of 1111 to 1115 (101) diff. Dims are 0.528" x 0.532" 0.532" should be 0.530" R.L. machine malfunction	11.11.14 PS/10/17	Finish saddles, do test fit on skid w/ XHole cut. GET ENG DISPOSITION	To Be Done on Split - 1 w/o.	11/11/24	11.11.14 PS/10/17	11/11/24
						11/11/24		
11.11.18	110		11/21/11 PS/10/42	SCRAP 11.11.18 C/A → Place Dial indicator to tell when part is clamped correctly, on all parts.	11/14/22	11/21/11 PS/10/42	11/21/11 PS/10/42	11/14/24

NOTE: Date & initial all entries

176.35 x 3 = 529.05

110 — training (F. Kironen)
because of over-tightening this
is teaching method only.

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Item ID: D2661-2

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Setup Start



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Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ FINISH TIME: _____	0.00 0.00							

OVEN TEMPERATURE: _____

DART AEROSPACE LTD		Work Order:	74474
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.128	.130	.131	.130	
B	0.100	0.140		.125	.125	.125	.125	.127	
C	1.250	1.270		1.140	1.138	1.139	1.138	1.139	
D	0.615	0.685		.675	.680	.680	.680	.680	
E	0.240	0.260		.249	.249	.250	.251	.251	
F	1.437	1.467		1.326	1.327	1.327	1.327	1.327	
G	0.210	0.230		.225	.225	.227	.227	.226	
H	0.100	0.180		.135	.137	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.577	1.576	1.576	1.576	1.576	
K	0.235	0.240		.237	.237	.237	.236	.236	
L	0.100	0.120		.112	.112	.112	.111	.111	
M	0.990	1.010		1.001	1.000	1.000	1.000	.998	
N	0.510	0.515		.510	.510	.510	.510	.510	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.796	.793	.796	.799	.796	
W	0.540	0.560		.546	.546	.549	.551	.551	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.258	.258	.258	.258	.258	
Z	0.912	0.932		.921	.924	.922	.923	.923	
AA	0.490	0.510		.500	.499	.499	.500	.499	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SMF / L.A.
Date:	11/11/11

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

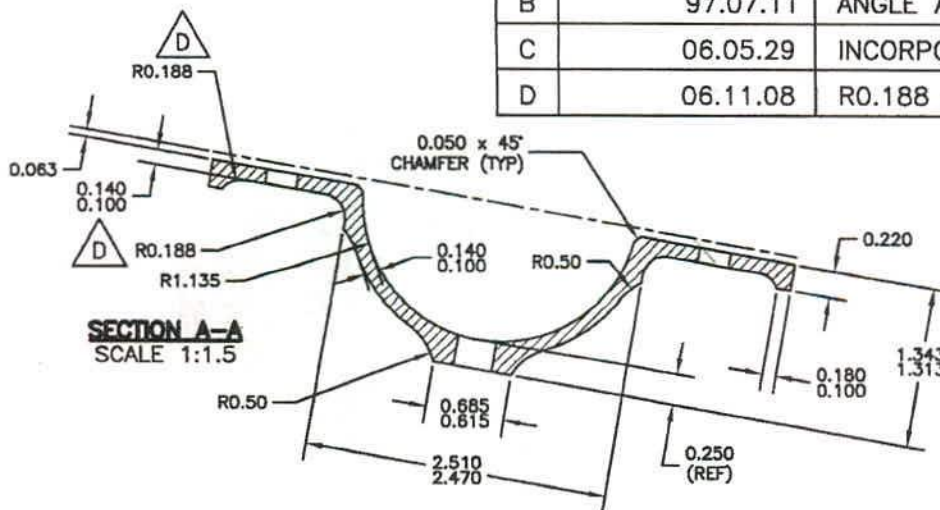
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.135	.135	.132			
B	0.100	0.140		.125	.125	.122			
C	1.125	1.145		1.139	1.141	1.137			
D	0.615	0.685		.680	.680	.680			
E	0.240	0.260		.251	.251	.251			
F	1.313	1.343		1.327	1.327	1.324			
G	0.210	0.230		.225	.227	.225			
H	0.100	0.180		.115	.121	.123			
I	2.470	2.510		2.490	2.490	2.490			
J	1.565	1.585		1.578	1.577	1.579			
K	0.235	0.240		.236	.236	.236			
L	0.100	0.120		.111	.111	.111			
M	0.990	1.010		1.000	.998	1.000			
N	0.510	0.515		.510	.510	.510			
O	5.990	6.010		6.000	6.000	6.000			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.500	2.500	2.500			
R	0.313	0.318		.314	.314	.314			
S	0.315	0.322		.316	.316	.316			
T	2.495	2.505		2.500	2.500	2.500			
U	1.357	1.367		1.362	1.362	1.362			
V	0.787	0.807		.797	.796	.799			
W	0.540	0.560		.533	.533	.535			
X	1.674	1.684		1.679	1.679	1.679			
Y	0.257	0.262		.257	.257	.257			
Z	0.912	0.932		.923	.923	.923			
AA	0.490	0.510		.497	.498	.497			
AB	0.178	0.198		.188	.188	.188			
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>FK</i>	Audited by:
Date: <i>11/11/17</i>	Date:

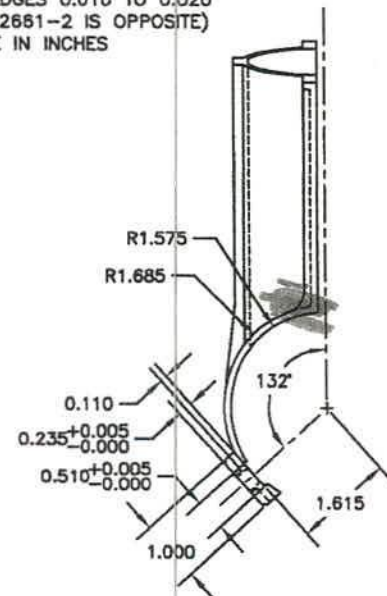
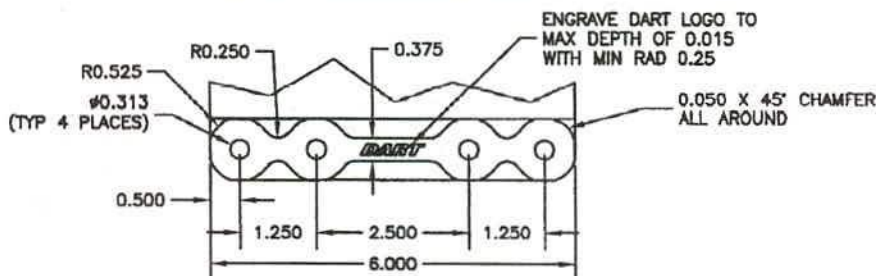
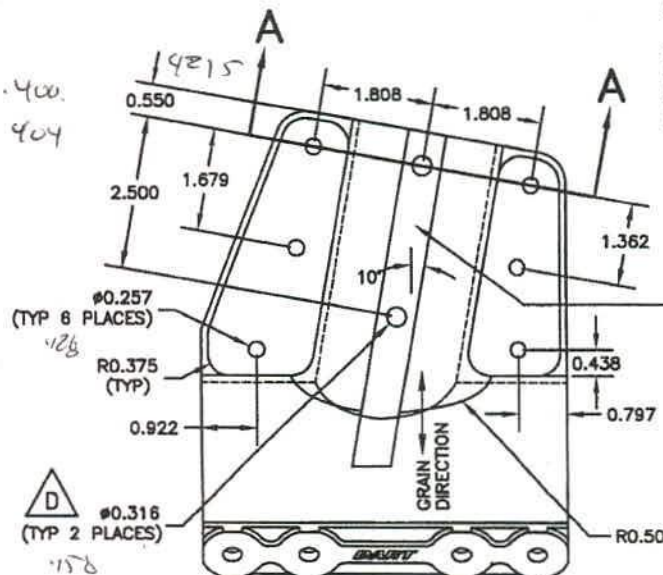
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	

DART

DESIGN	<i>CH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>CH</i>	DRAWING NO.	REV.-D
				D2661	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE OUTSIDE	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$			

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2661-1 SADDLE OUTSIDE**

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